

Work Order ID 77057

77057

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November-25-11 8:33:18 AM

Item ID: D3278-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Support Assembly
 Start Date: 25/11/2011 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 09/12/2011 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: M.C.J Date: 11/11/25 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3278	Rev C

100 0.00
100 Small Fab
 Small Fab Memo 0.00
 Small Fab Rivet spacers with support as per Dwg D3278.

EP 12/01/19 (40)

110 0.00
110 QC5- Inspect part completeness to step on W/O
 QC Memo 0.00
 Quality Control

center
 (40)

120 0.00
120 Small Fab
 Small Fab Memo 0.00
 Small Fab Assemble support as per Dwg D3278.***DO NOT TIGHTEN
 BOLTS***Identify as D3278-041

EP 12/01/24 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				counts <u>x40</u>			
140 *140* Packaging Packaging	Identify as per dwg & Stock Location <u>ST 481</u> Memo	0.00 0.00				<u>(40x) SP/2-01-24.</u>			
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>12/1/25</u> <u>JD</u>

SP/2-01-24
EO

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Picklist Print

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Work Order ID: 77057

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Parent Item: D3278-041

D3278-041

Parent Item Name: Support Assembly

Start Date: 25/11/2011

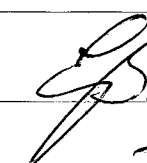
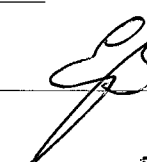
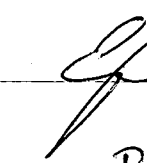
Required Date: 09/12/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: A04.04.19New issueKJ/JLM
IPP B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3278-1 *D3278-1* Support		Manufactured	No			100	Each	1.0000	1	40	**		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		1							
					73412	1							
D3278-2 *D3278-2* Support		Manufactured	No			100	Each	1.0000	1	40	**		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				CA		1							
					74879	1							
D3278-3 *D3278-3* Spacer		Manufactured	No			100	Each	2.0000	1	40	**		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		2							
					70984	2							

 12/01/19
 B 770572
 (40x)
 12/01/19
 B 77060
 (40x)
 12/01/19
 B 77061 (40x)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Work Order ID: 77057

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Parent Item: D3278-041

D3278-041

Parent Item Name: Support Assembly

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 40.00

Required Qty: 40.00

MS21042L4

Purchased

No

100

Each

10,709.00

2

80

MS21042L 4

Nut

**

EP 12/01/23

Location

Loc Qty

Loc Code

ST300

546

117441

51

117601

362

118451

133

ST516

5163

119017

5163

ST518

5000

119075

5000

80

AN4-13A

Purchased

No

120

Each

953.0000

2

80

AN4-13A

Bolt

**

EP 12/01/23

Location

Loc Qty

Loc Code

ST357

953

118078

17

118838

436

119449

500

80

AN960JD416

NAS1149D0463J

Purchased

No

120

Each

0.0000

4

160

AN960JD416

Washer

**

LD M119075 (160x)

EP 12/01/23

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Parent Item: D3278-041

D3278-041

Parent Item Name: Support Assembly

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 40.00

Required Qty: 40.00

D2230-1

Manufactured No

120

Each

46.0000

2

80

D2230-1

Lug

Location

Loc Qty

Loc Code

ST470

37

72811

37

ST476

9

67826

6

70974

3

12/01/23

876640
802

MS20426AD3-6

Purchased

No

120

Each

2,889.000

4

160

MS20426AD3-6

Rivet

Location

Loc Qty

Loc Code

ST316

2889

105055

115

116289

2774

12/01/19
160

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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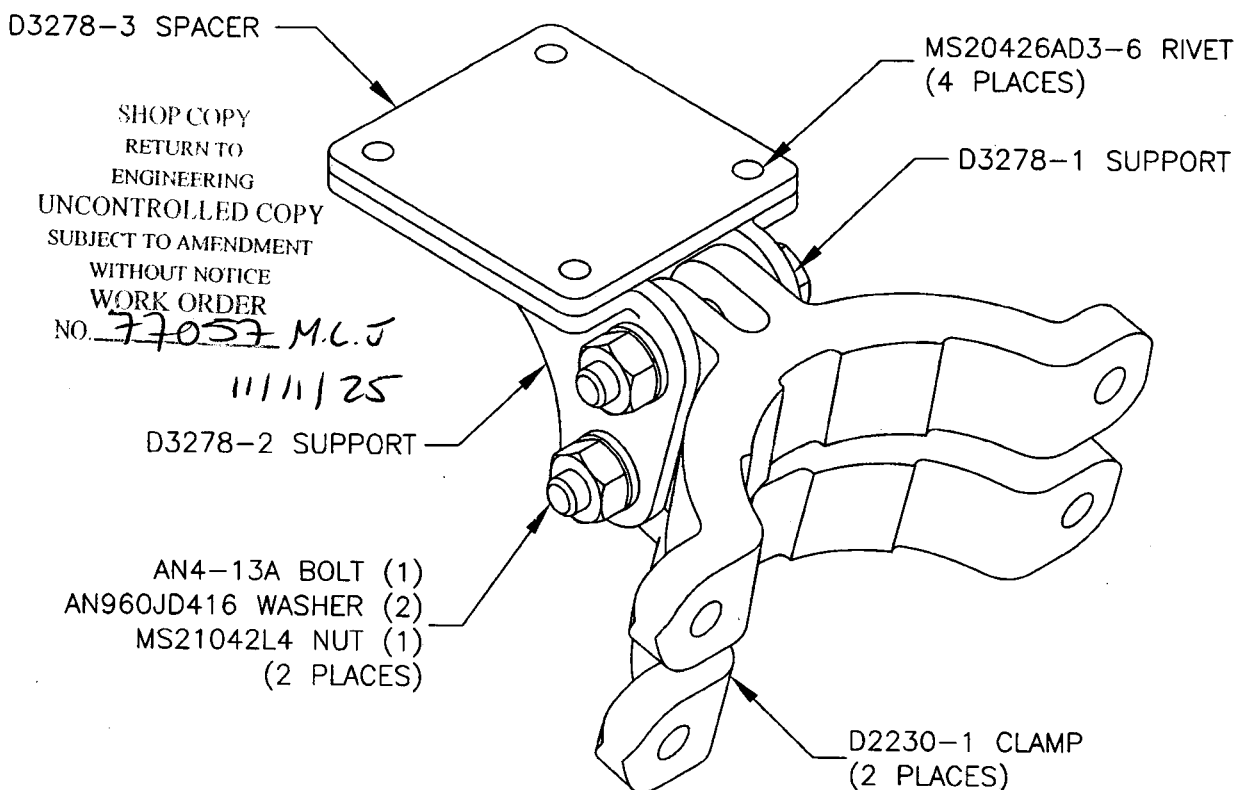
NOTE: Date & initial all entries

DART

DESIGN <i>97</i>	DRAWN BY <i>SC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-08

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

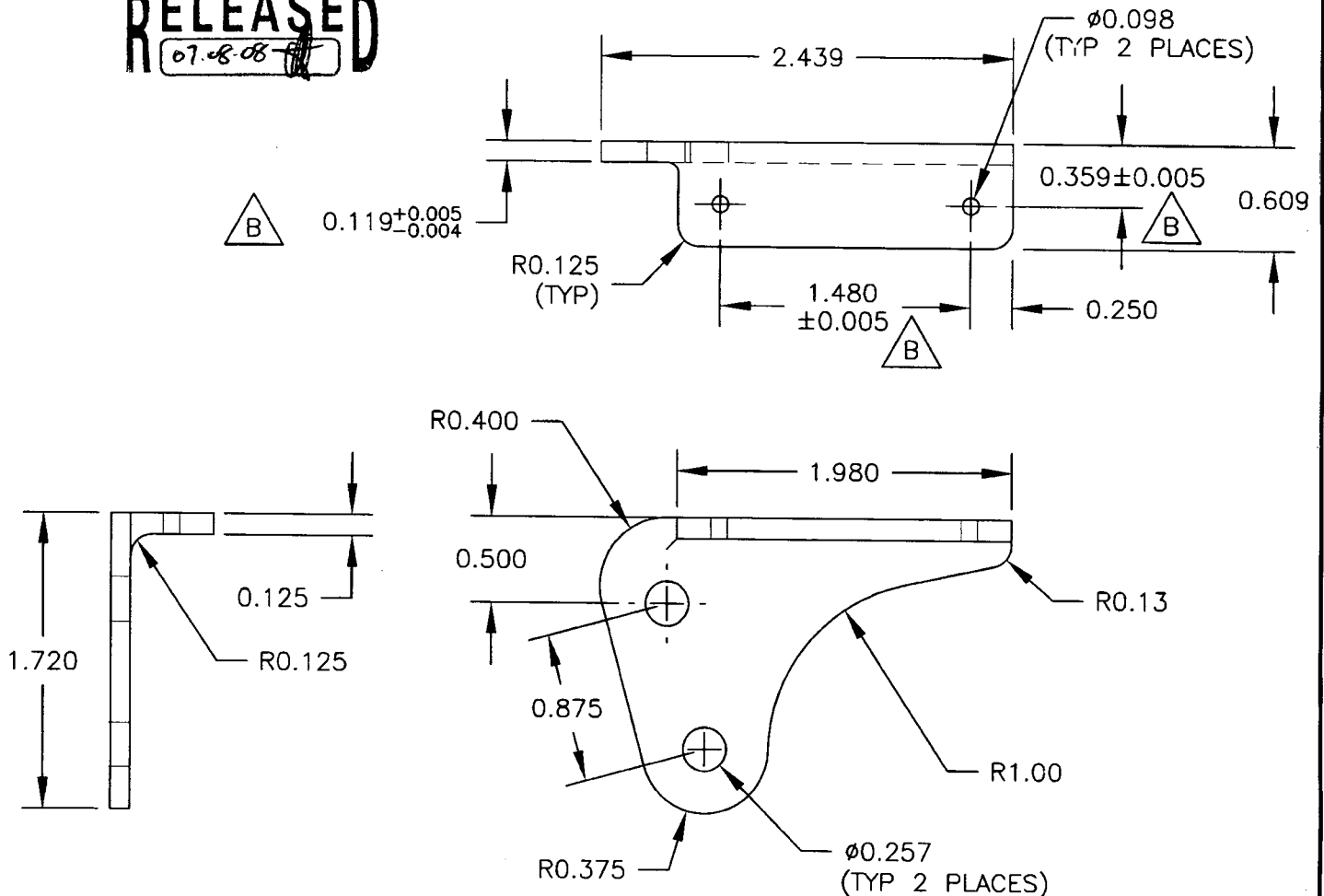
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NOTE: Date & initial all entries

DART

DESIGN <i>qp</i>	DRAWN BY <i>bc</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>js</i>	APPROVED <i>js</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED
07-08-08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd

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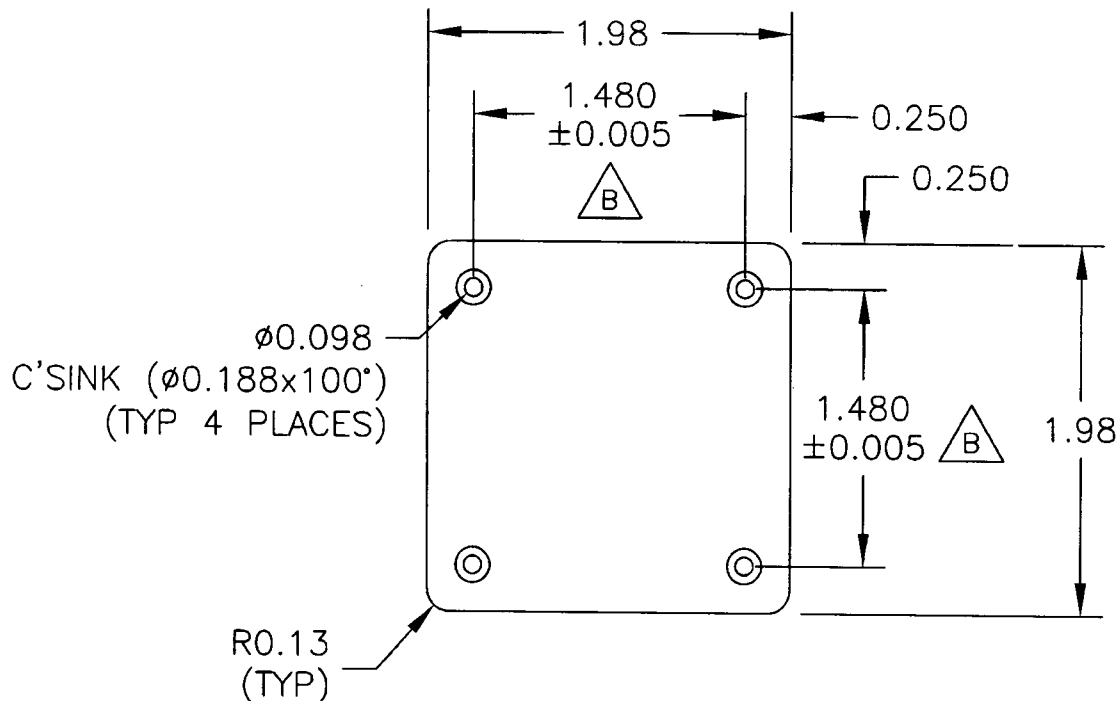
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NOTE: Date & initial all entries

DART

DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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